

Work Order ID 91350

October-05-12 9:14:30 AM

91350

Page 1

Item ID: D3901-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 04/10/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 19/10/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: 

Date: 12-10-4

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D3901 E

100

0.00

100

Cold Saw

Memo

0.00

cmf 12/11/02

12

Hyd Mech

Cut blanks at 67.50"

110

0.00

110

HAAS 1

Memo

0.00

ba 12/11/03

12

DA:
08
9-83

HAAS CNC vertical machine #1

1-Mill as per folio FB090 & dwg D3901,

FOLIO REV: AA

DWG REV: E

2-Deburr as required

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
--	--	--	--	---	--	---	--	--	--	--	--

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

D.A. 12/11/03

12

0

*DAS
08
9-89*

120

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

130

QC8- Inspect parts - second check

0.00

and 12/11/05

12

0

*DAS
14
9-89*

130

QC

Memo

0.00

Quality Control

EXTRA MATERIAL WILL BE CUT ON ASSEMBLY

140

Identify as per dwg & Stock Location: *W/A*

0.00

(x12) ml 12-11-05

140

Packaging

Memo

0.00

Packaging

NCR: Yes / No

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Other <input type="checkbox"/>											
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Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
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Page 3

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/11/09
MLJ 12-11-05

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

October-05-12 9:14:33 AM

Page 1

Work Order ID: 91350

91350

Parent Item: D3901-3

D3901-3

Parent Item Name: Bar

Start Date: 04/10/2012

Required Date: 19/10/2012

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP RevA: New issue DD verified by:EC
on cnc JFS 12/02/13 verified by:JLM

IPP RevB: Now

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	704.8150	5.573	70.39579			

M304B0 250x0 500

**

304 BAR .250 x .500

Location

Loc Qty

Loc Code

MAT050

704.815

121216

133.88

122008

66.87

122981

0.065

123216

504

M123535 X 74'

am 12/11/02

NCR: Yes / No

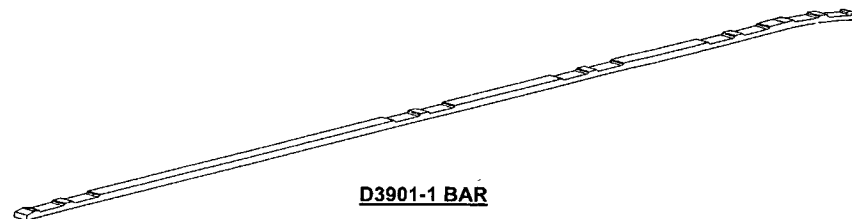
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

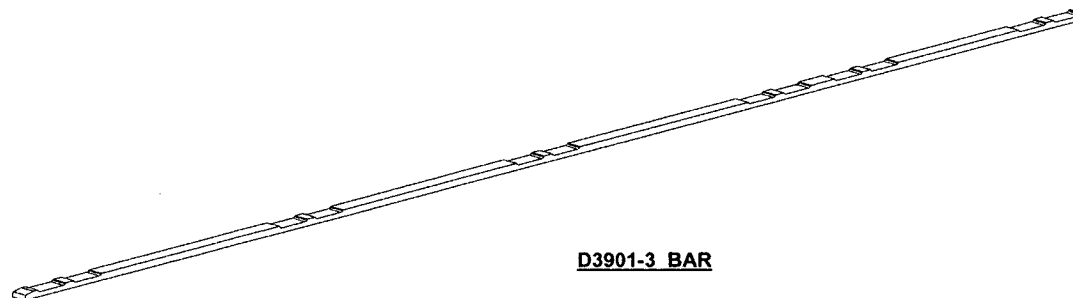
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

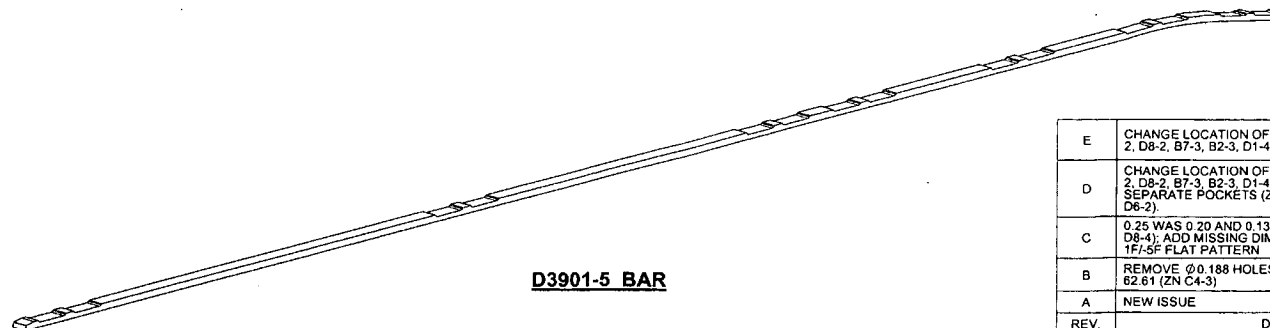
FAULT CATEGORY										
Landing Gear			General							
<input type="checkbox"/> Bending	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Cracks	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Wave/Twist in Tube
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						<input type="checkbox"/> Other				



D3901-1 BAR



D3901-3 BAR

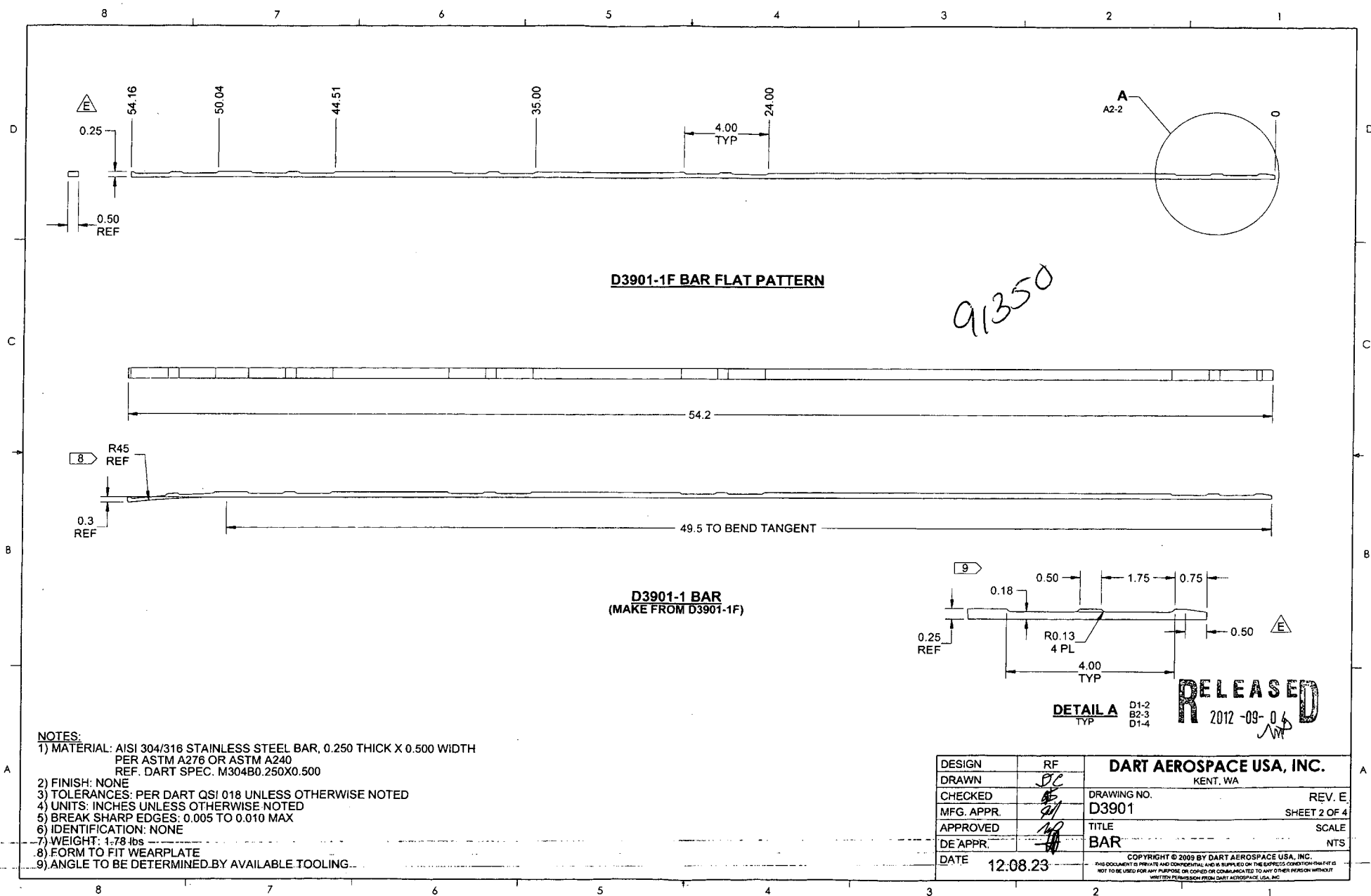


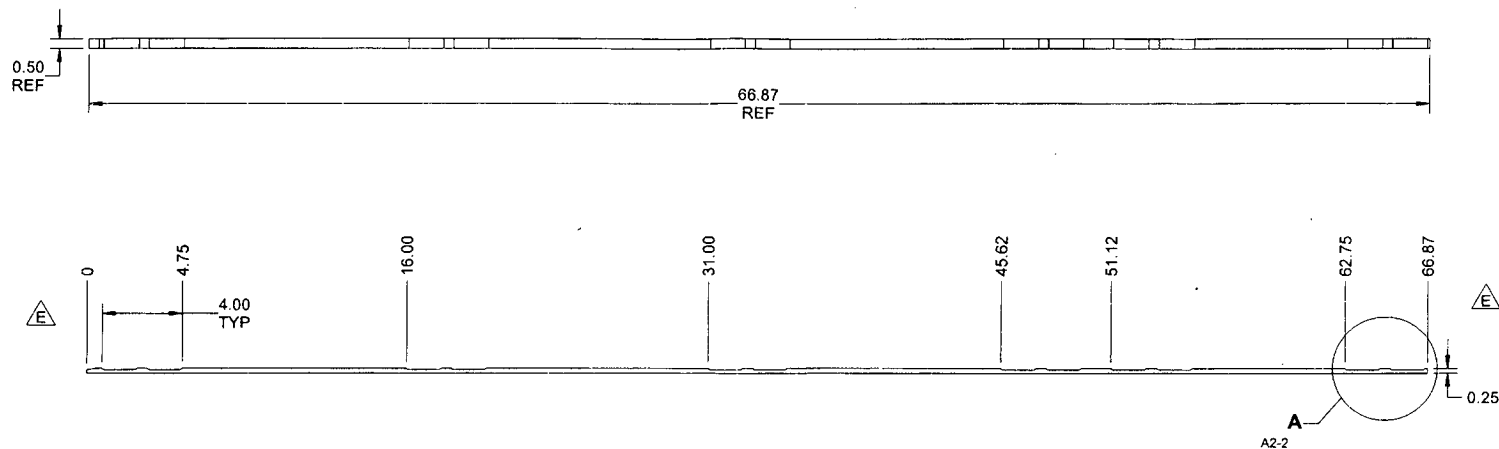
D3901-5 BAR

*12-10-4
9350*

RELEASED
2012-09-04
MP

E	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN B1-2, D8-2, B7-3, B2-3, D1-4, D7-4).	DC	12.08.23
D	CHANGE LOCATION OF END POCKETS ON -1/-3/-5 (ZN D1-2, D8-2, B7-3, B2-3, D1-4, D8-4). SPLIT POCKETS INTO TWO SEPARATE POCKETS (ZN A2-2). ADD POCKET TO -1 (ZN D6-2).	DC	12.08.21
C	0.25 WAS 0.20 AND 0.130 WAS 0.080 (ZN B2-2, B1-2, B1-3, D8-4); ADD MISSING DIMENSIONS (ZN C5-3); ADD D3901-1F/SF FLAT PATTERN	RF	12.01.24
B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.61 (ZN C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D3901 TITLE BAR SCALE NTS SHEET 1 OF 4 REV. E COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	<i>BC</i>		
CHECKED	<i>BC</i>		
MFG. APPR.	<i>21</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	12.08.23		





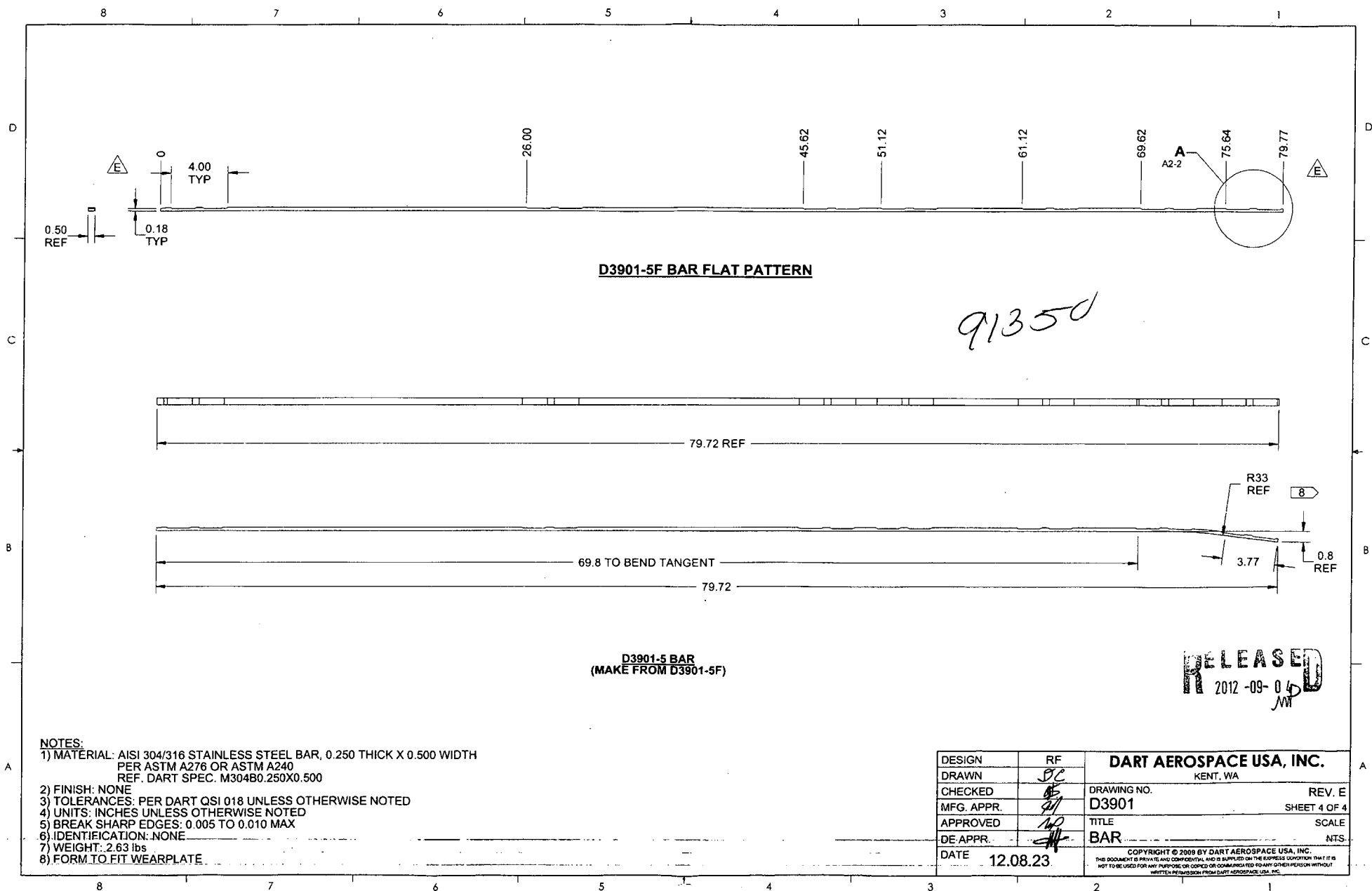
D3901-3 BAR

91350

RELEASED
2012-09-04
MP

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 THICK X 0.500 WIDTH
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.21 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	SI	D3901	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	BAR	NTS
DATE	12.08.23	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.63 lbs
- 8) FORM TO FIT WEARPLATE

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	JC	KENT, WA	
CHECKED	GE	DRAWING NO.	REV. E
MFG. APPR.	ST	D3901	SHEET 4 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	BAR	NTS
DATE	12.08.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

